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(54) **SUN VISOR AND COVER ATTACHMENT METHOD**

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(58) **Field of Search** 296/97.1, 97.5, 296/97.9, 97.8, 97.12, 97.2, 97.6, 97.11; 362/135; 2/195.1

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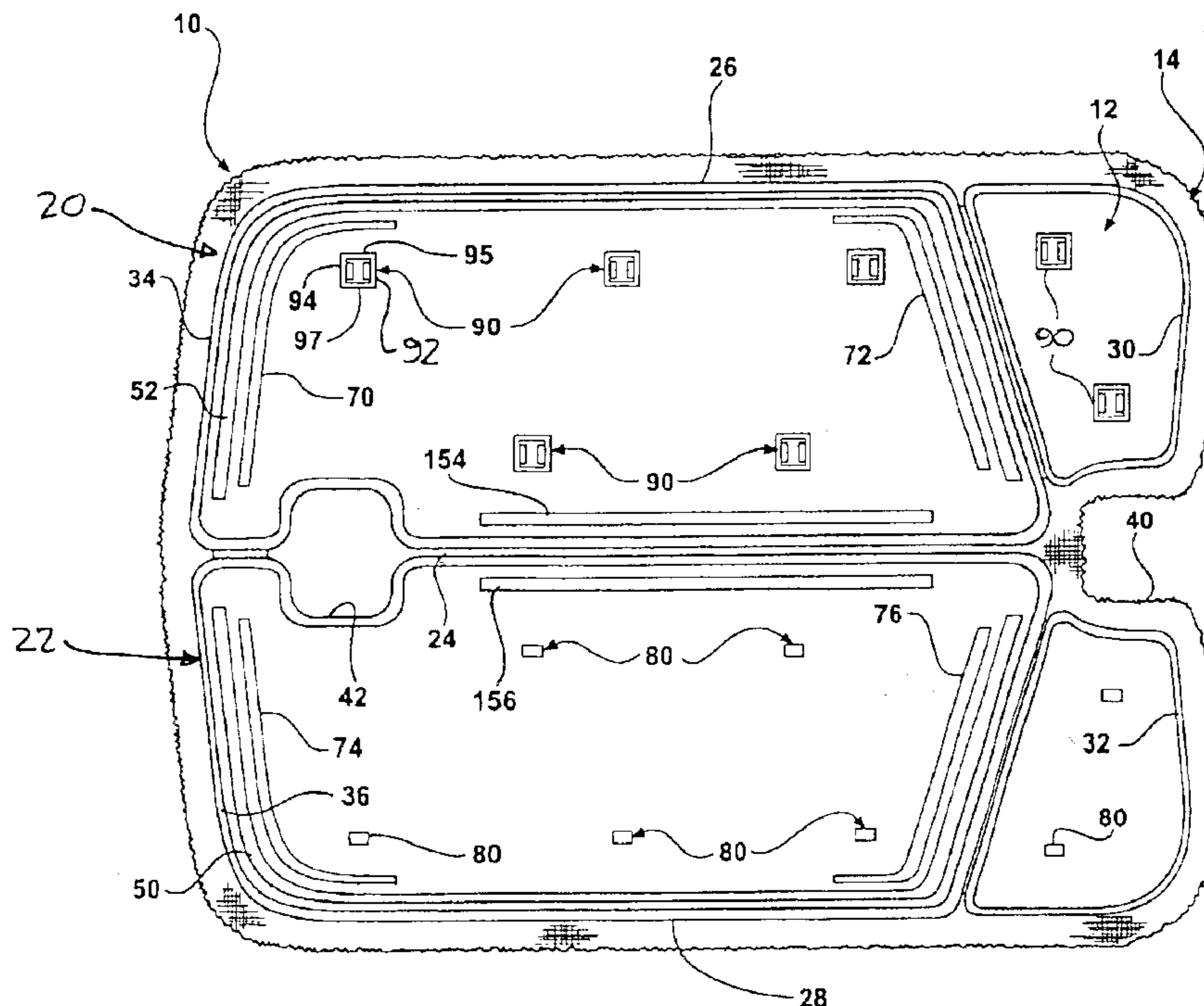
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(57) **ABSTRACT**

The sun visor has a decorative cover securely affixed over a core formed of foldable first and second core halves. Receiving surfaces defining a planar end are formed on each of the first and second core halves and extend substantially continuously between opposed ends. The edges of the cover are folded over onto the receiving surfaces and fixed to the receiving surfaces

14 Claims, 10 Drawing Sheets



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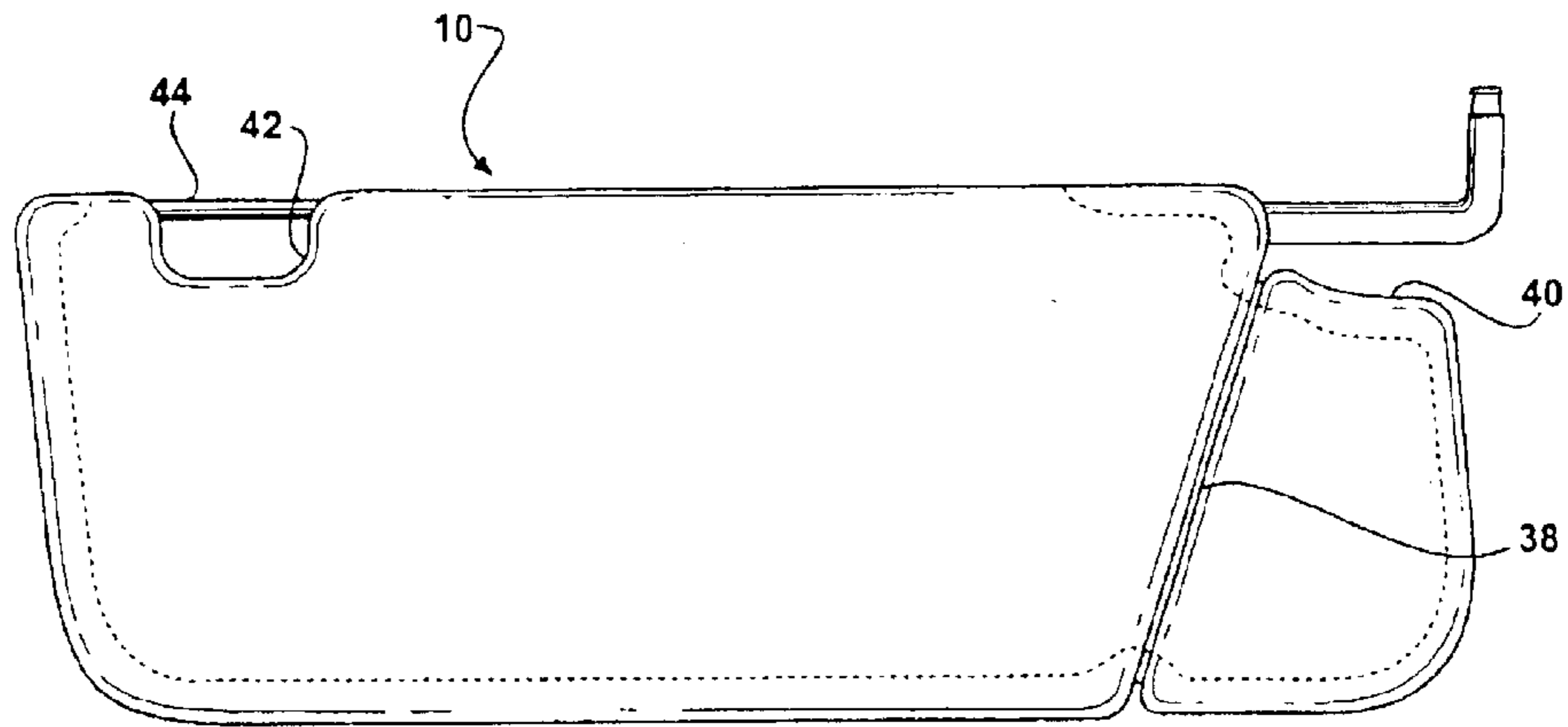


FIG - 1

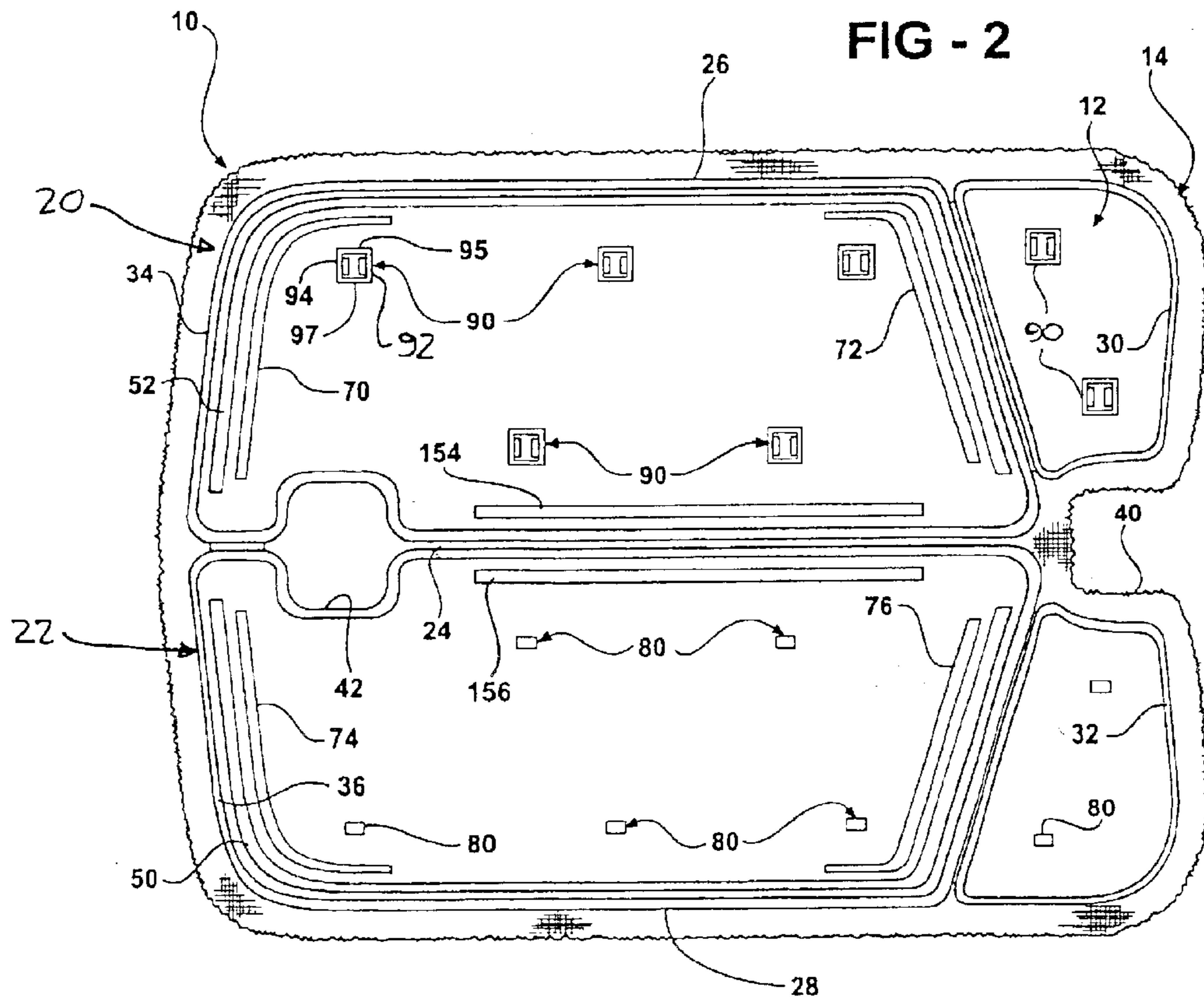


FIG - 2

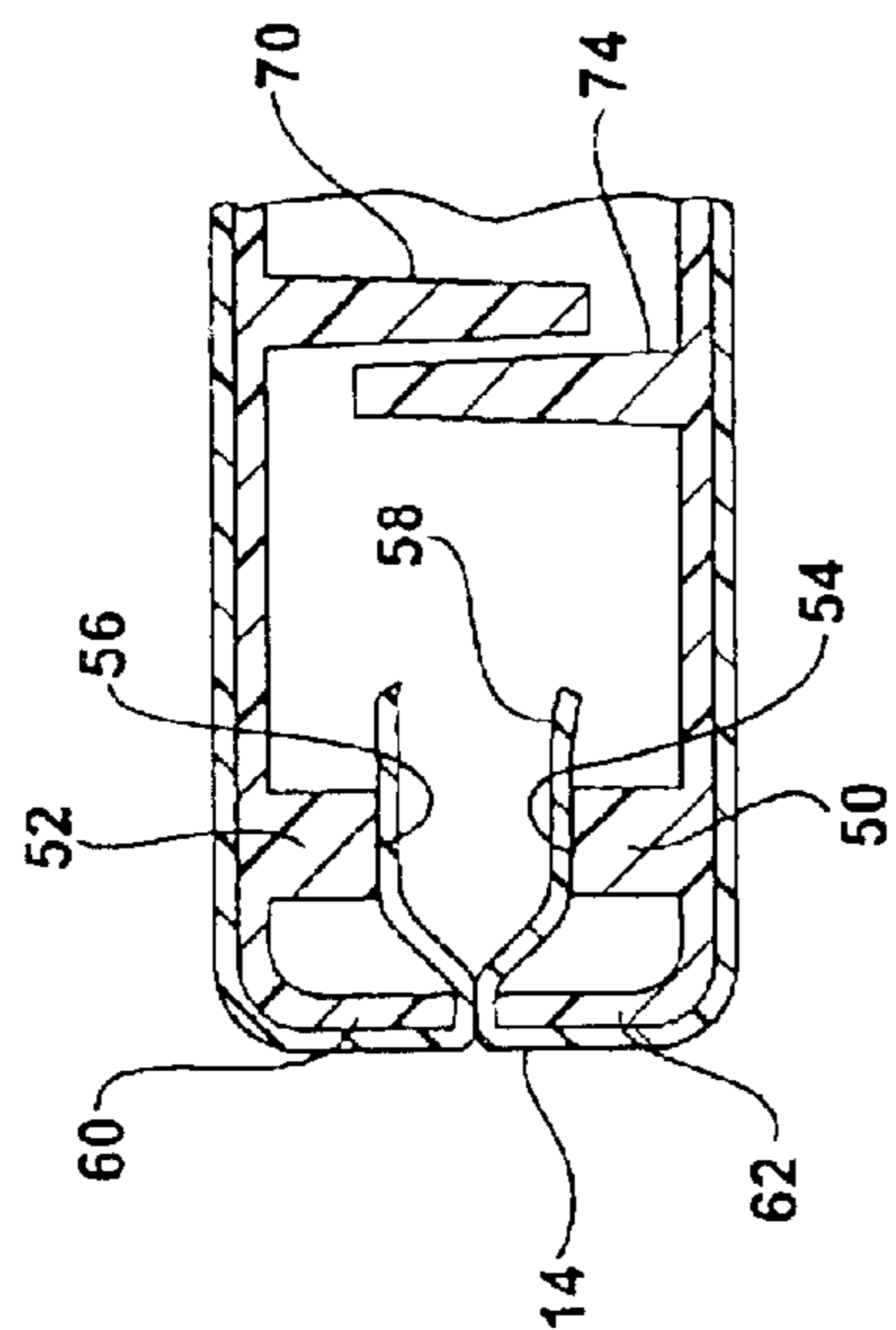


FIG - 3

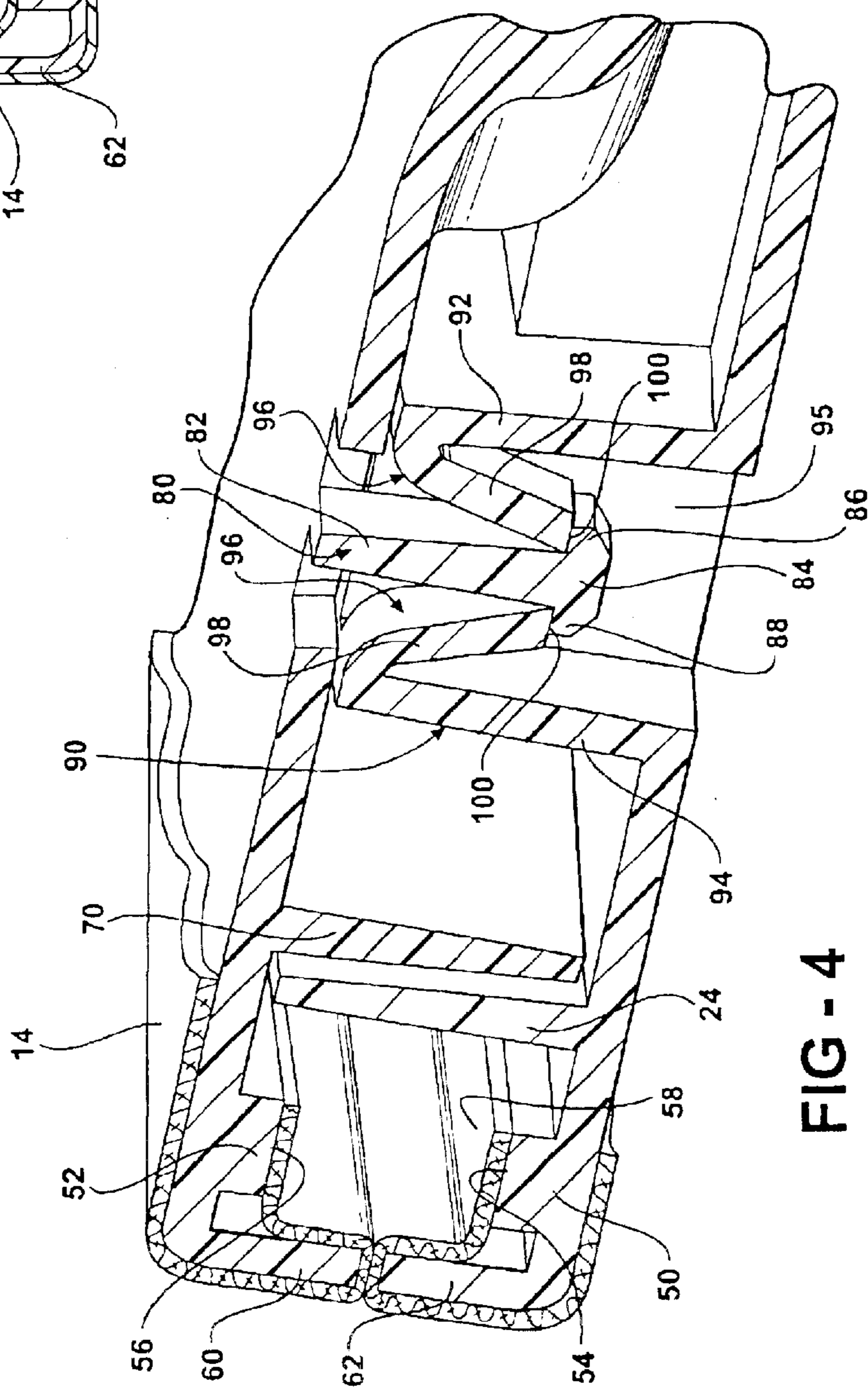


FIG - 4

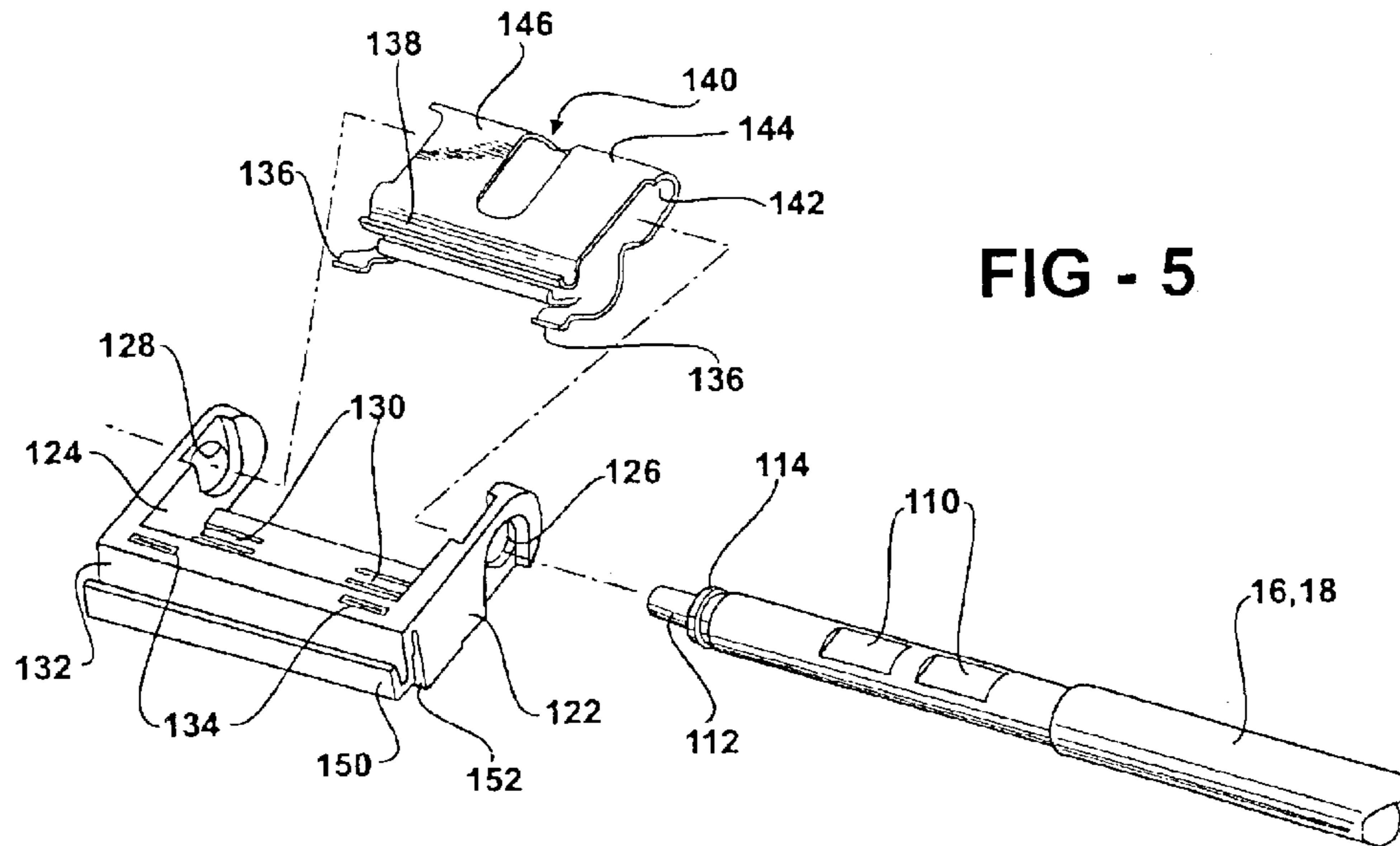


FIG - 5

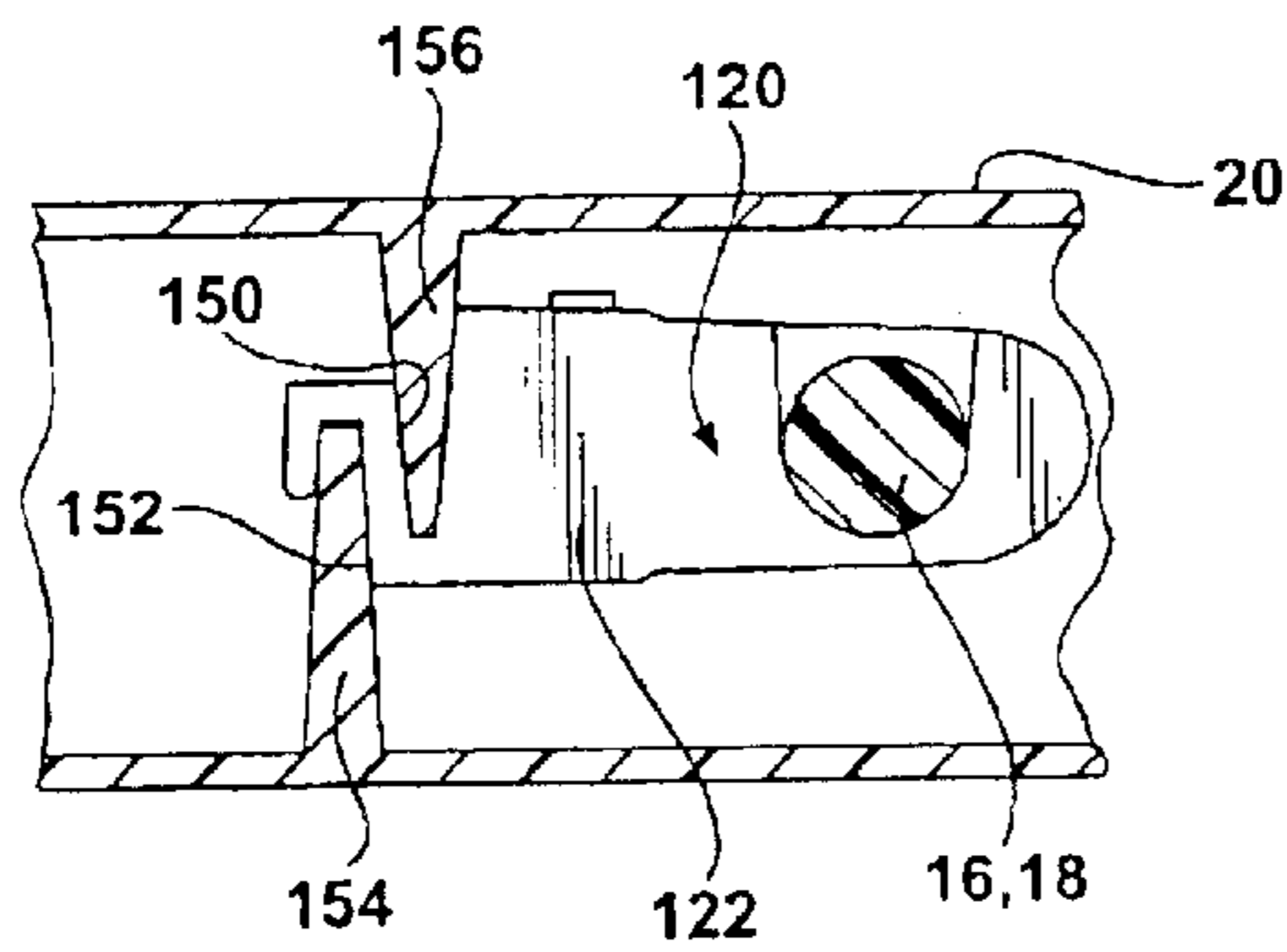


FIG - 6

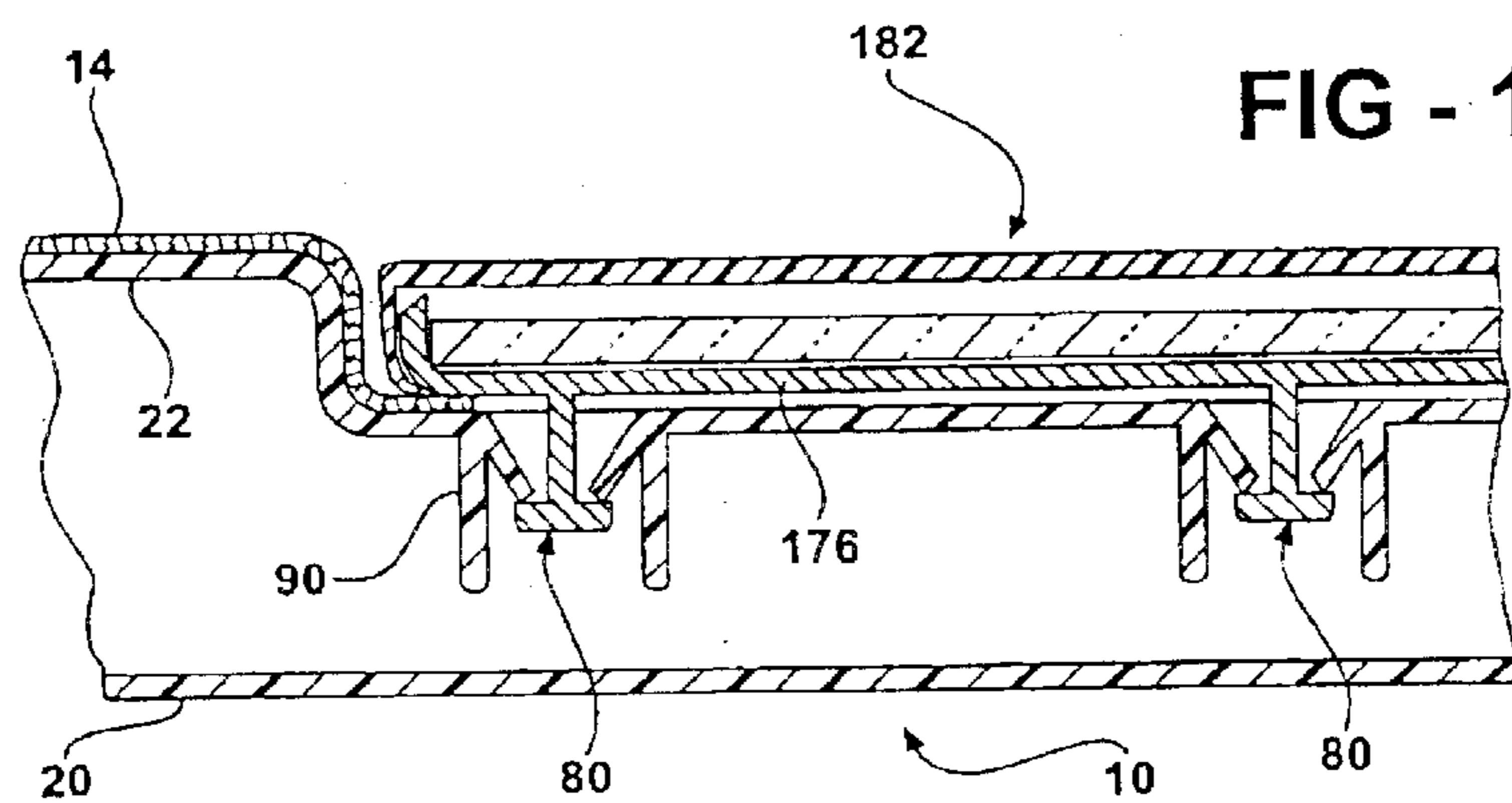


FIG - 13

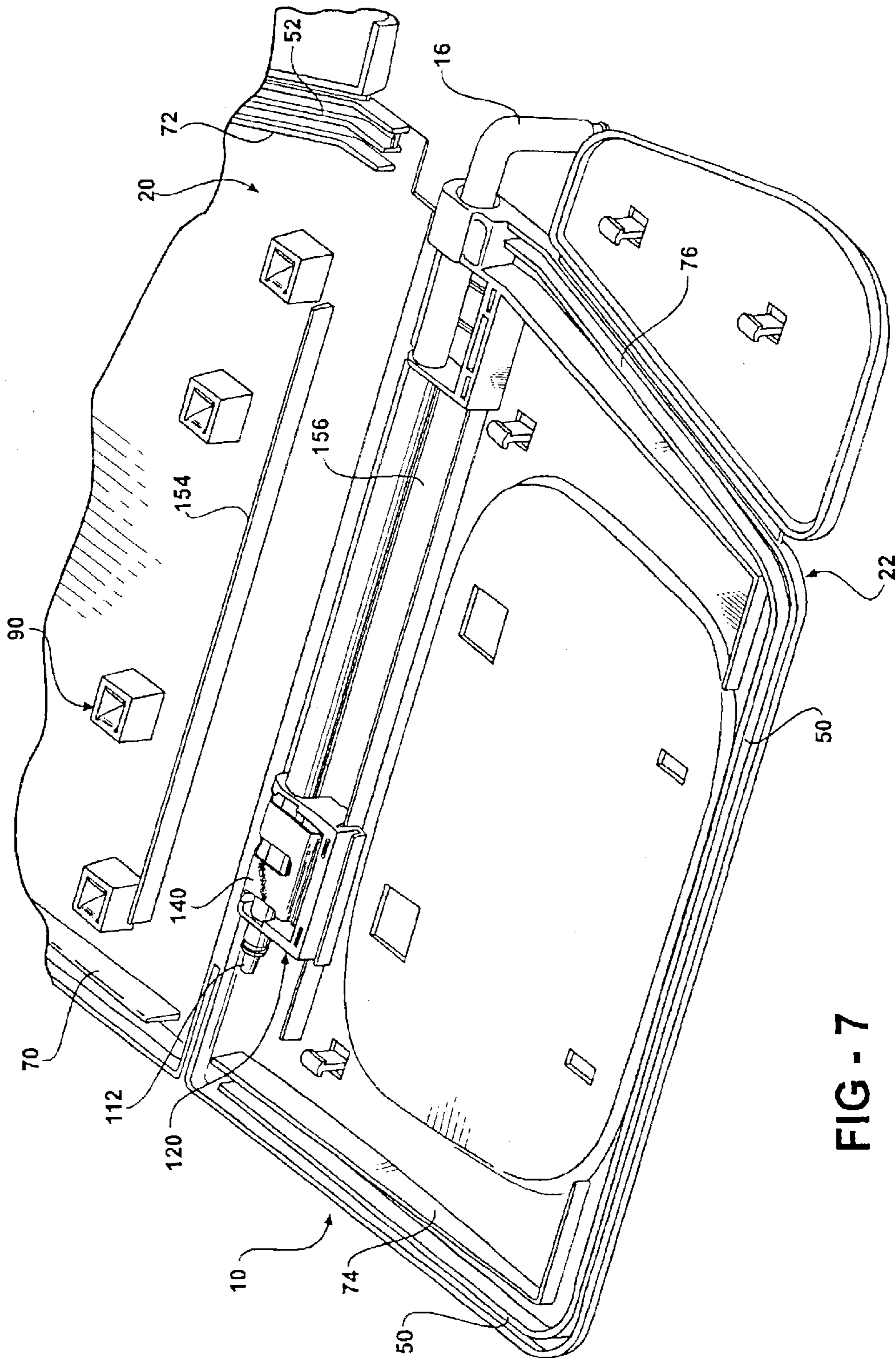


FIG - 7

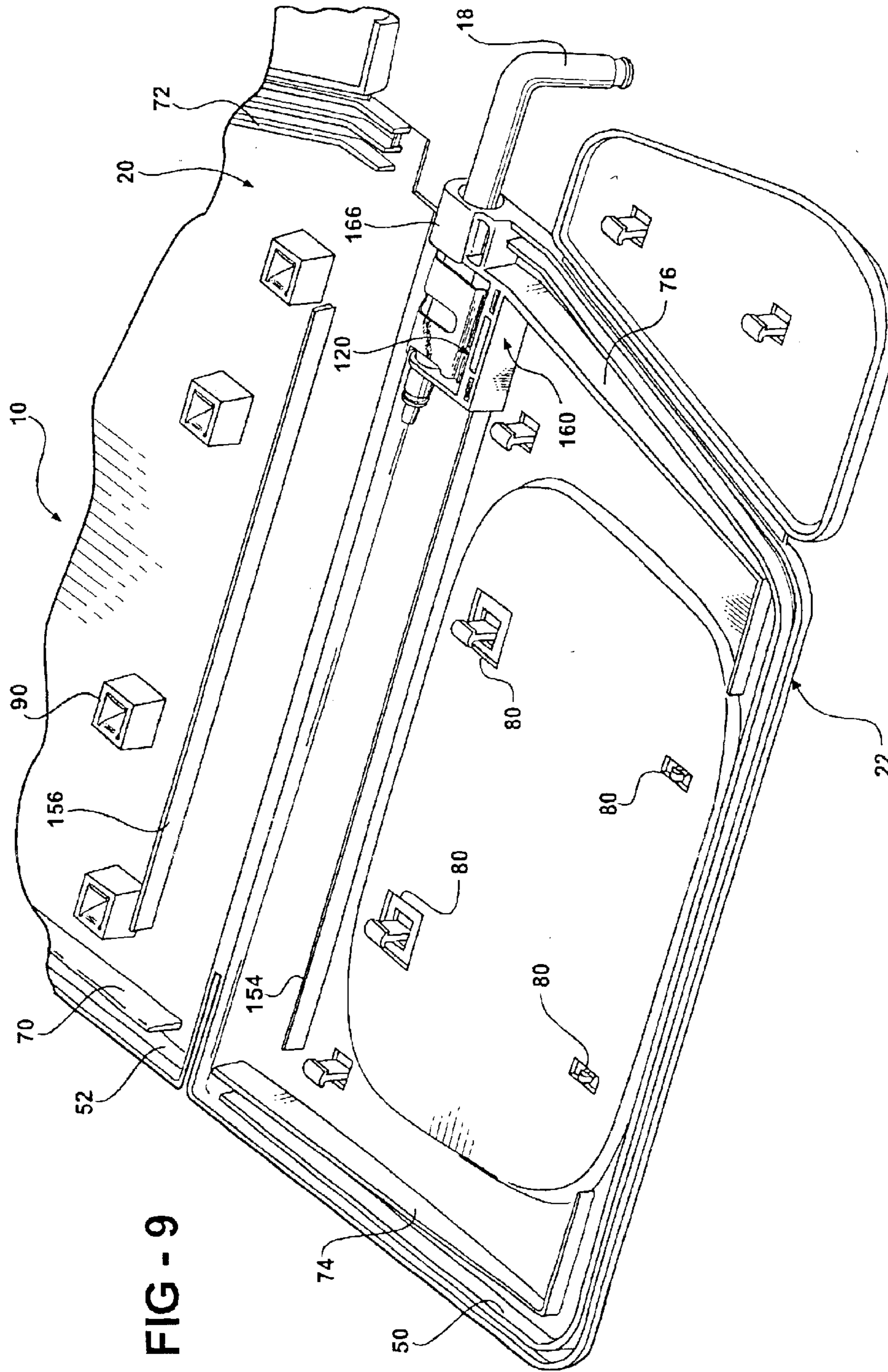
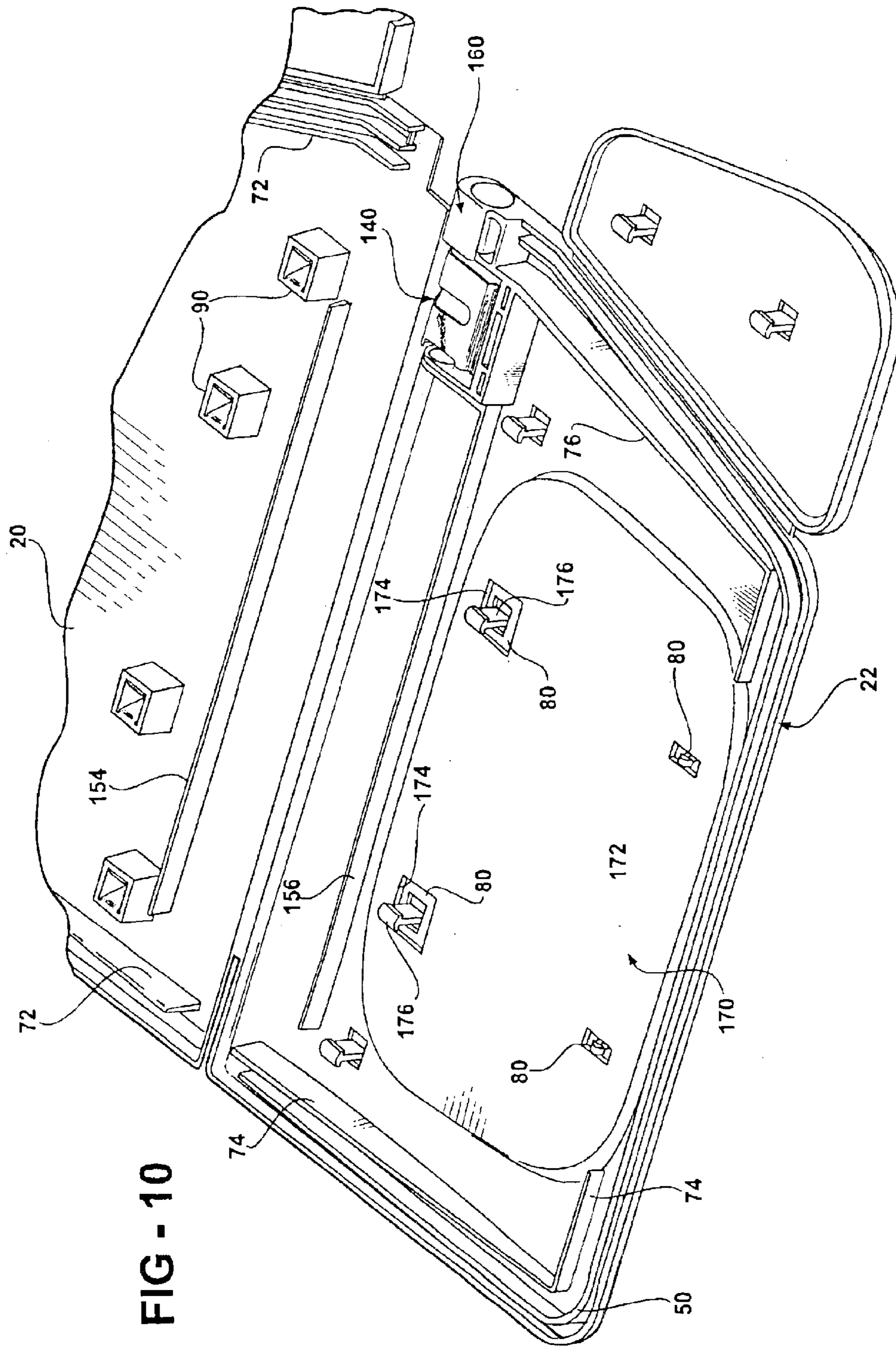


FIG - 9



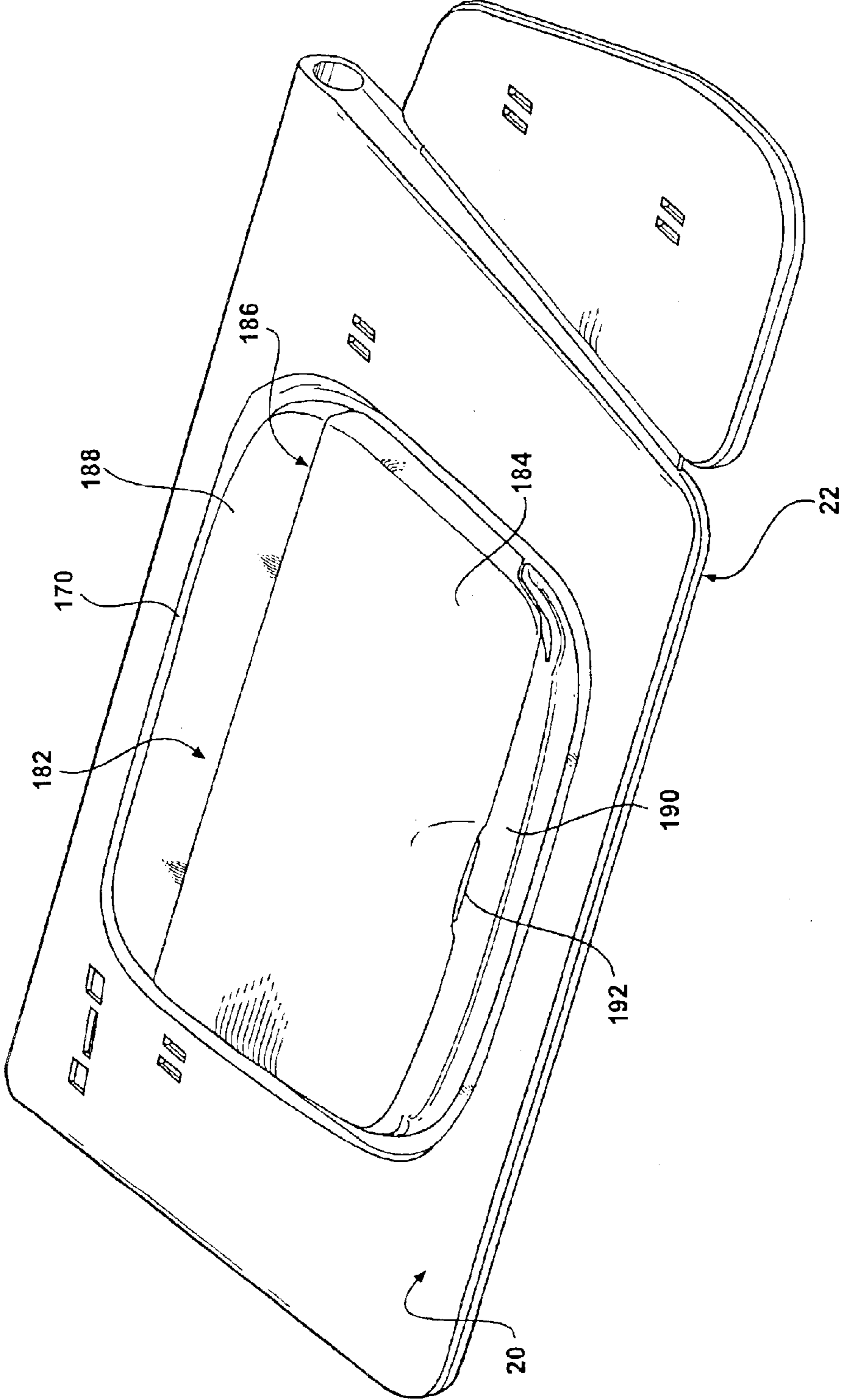


FIG - 11

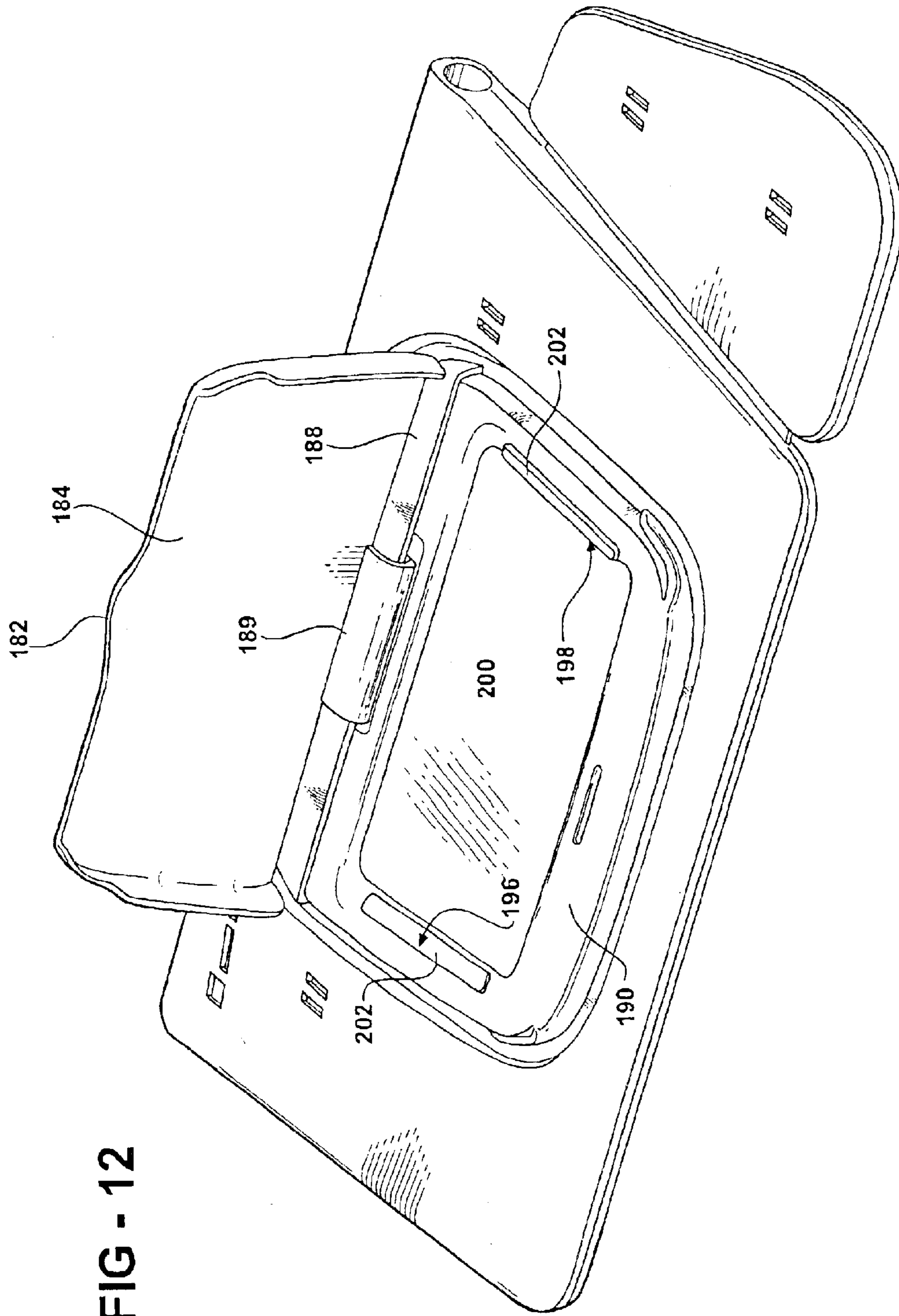


FIG - 12

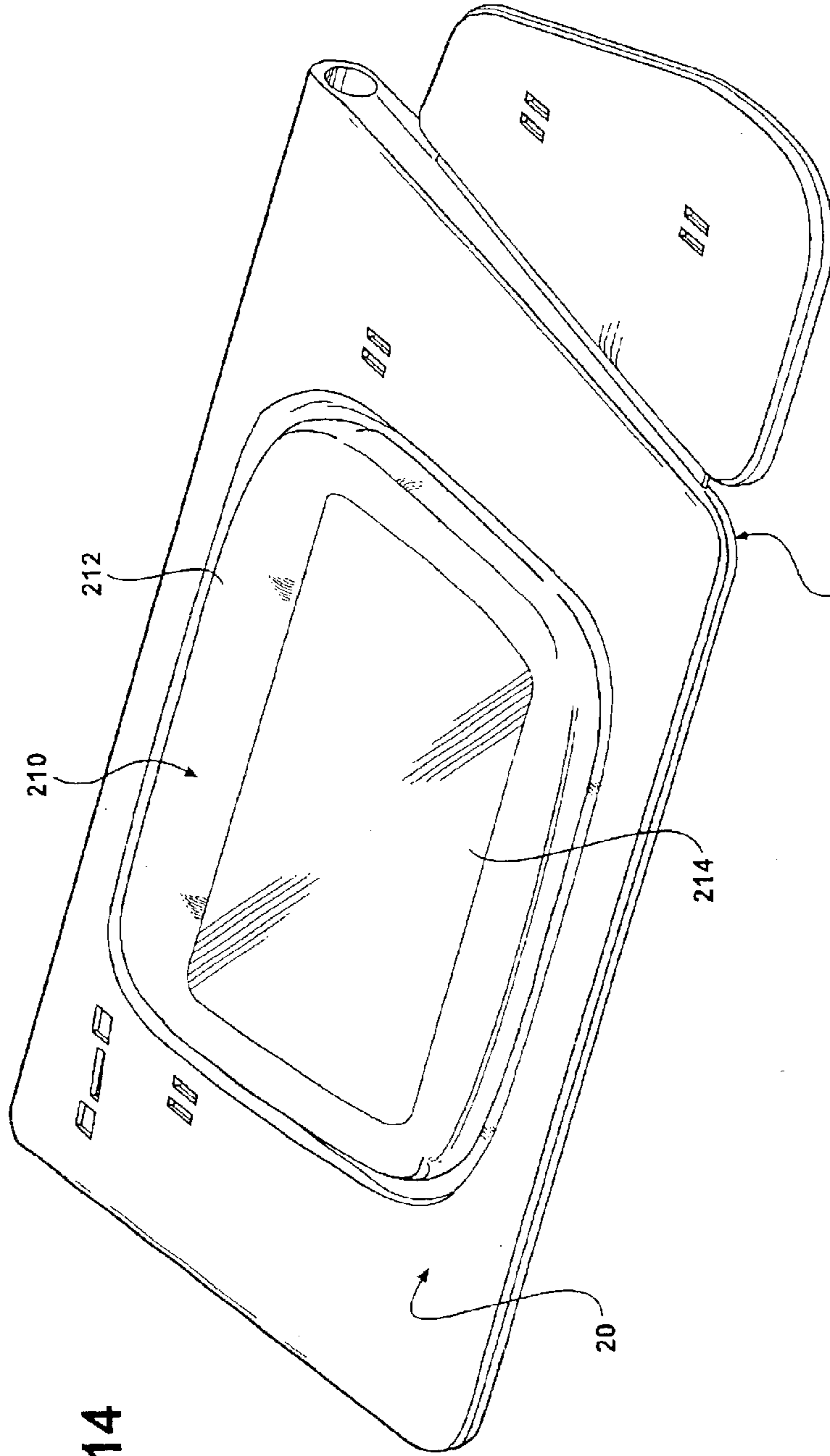


FIG - 14

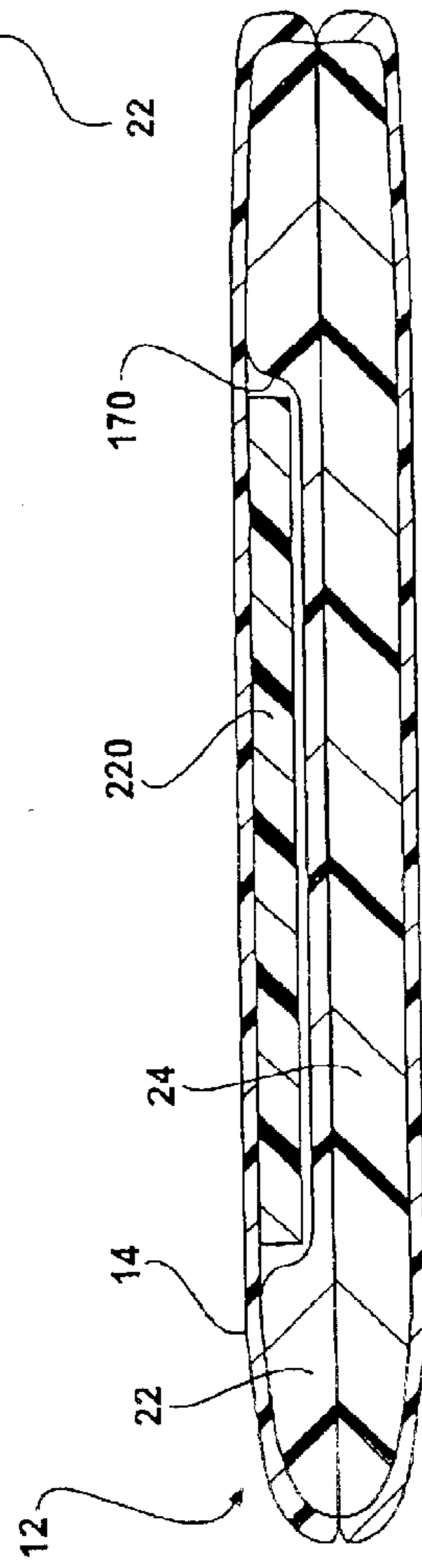


FIG - 15

SUN VISOR AND COVER ATTACHMENT METHOD

BACKGROUND

The present invention relates, in general, to vehicle sun visors.

Sun visors are used in vehicles to provide front and side window protection from sunlight entry. Such sun visors are pivotal about a longitudinal axis between a stowed position adjacent the headliner and a deployed position angularly extending from the headliner. Most sun visors can also be unlocked from a headliner mounted clip or D-ring and pivoted to the side window about a support arm attached to the vehicle headliner. A biasing means is typically mounted within the visor to prevent movement and noise when the sun visor is in the stowed position.

Over the years, various enhancements or features have been added for sun visors to increase their versatility as well as to add other convenience factors to the vehicle occupants.

One such feature is the telescopic extension of the entire sun visor along the longitudinal axis of the support arm to enable the sun visor to be repositioned laterally across the windshield or the side window to block sun light entry in a particular direction for an occupant.

Another common feature is a mirror with or without a pivotal cover and with or without an illumination means which is mounted in one surface of the sun visor, typically the surface facing the headliner when the sun visor is in the stowed position. The sun visor need only be pivoted to the angular downward extending position to allow use of the mirror.

When an illumination means, such as lamps, are provided around the mirror, electrical conductors or wires extend through the A pillar of the vehicle body and the support arm to the individual lamps in the sun visor.

Various means have been provided to mount fabric or decorative covers over the plastic sun visor core. One such mount traps the ends of the fabric cover between the two clam shell core halves when the halves are moved to their closed, locked position. Another mount utilizes projections on the inner surfaces of the core halves over which the inner edges of the fabric cover are forced.

Heat stake projections have also been provided about the periphery of the core halves. In this mounting technique, the edges of the fabric cover are forced over the heat stake projections and then heat is applied to melt the stakes through the interstices of the fabric cover to fixedly retain the inner edges of the cover in a fixed position on the sun visor core.

Despite the improvements which have been made to vehicle sun visors, it would still be desirable to provide an improved sun visor which is easier to manufacture, have a more pleasing exterior aesthetic appearance, can be manufactured at a lower cost, and has improved buzz, squeak and rattle control features.

SUMMARY

The present invention is a sun visor having a unique decorative or outer fabric cover attachment structure and method.

In one aspect, the inventive method includes the steps of forming a core with first and second core halves oppositely extending from a common hinge edge. The method also includes forming a receiving surface on each of the first and

second core halves spaced from a periphery of the first and second core halves. The method further includes the step of overlaying the core over a cover with the edge portions of the cover folded over the peripheral edges of the first and second core halves into engagement with the receiving surfaces on the first and second core halves. Finally, the edges of the cover are joined to the receiving surfaces.

In another aspect, the method further includes the step of forming the receiving surface on at least one of the first and second core halves in the form of a continuous surface. The continuous surface, in one aspect, has a planar end.

The receiving surfaces in the first and second core halves are positioned to overlay each other when the first and second core halves are moved to the closed, assembled position.

The present invention also defines a sun visor including a core with the first and second foldable core halves, and a receiving surface on each of the first and second core halves spaced from a periphery of each of the first and second core halves. A cover has edges folded over the periphery of the first and second core halves and heat joined to the receiving surfaces on the first and second core halves.

In one aspect, the receiving surface in each of the first and second halves defines a continuous surface between opposed ends.

In one aspect, the receiving surface defines a planar end raised from the plane of a major portion of each of the first and second core halves. In another aspect, the receiving surfaces in the first and second core halves overlay each other in alignment when the first and second core halves are folded together into a closed, assembled position.

The cover attachment structure and method of the present invention provides a secure cover attachment to a sun visor core over a substantially continuous portion of the peripheral edges of the two core halves. This insures a more secure and smoother attachment of the cover to the core as compared to the typical prior art use of spaced projections or spikes in the core halves over which the fabric cover is forcibly urged and then heat welded together.

BRIEF DESCRIPTION OF THE DRAWING

The various features, advantages and other uses of the present invention will become more apparent by referring to the following detailed description and drawing in which:

FIG. 1 is a perspective view of a completely assembled sun visor according to one aspect of the present invention;

FIG. 2 is an elevational view of an open clam shell core for the sun visor shown in FIG. 1, depicting the initial step of attaching the fabric cover to the core;

FIG. 3 is an enlarged, cross-sectional view of one corner of the clam shell core in the closed position showing the edge fold and edge material attached to the core;

FIG. 4 is an enlarged, perspective view of the corner of the core shown in FIG. 3;

FIG. 5 is an exploded, perspective view of the slide carrier, clip and large support rod according to one aspect of the present invention;

FIG. 6 is a cross sectional view showing the slider carrier, clip and support rod in a closed core position;

FIG. 7 is a perspective view of the sun visor of FIG. 1 depicting the slider means in the normal, retracted position;

FIG. 8 is a perspective view similar to FIG. 7, but showing the slide carrier in the fully extended sun visor position;

FIG. 9 is a perspective view of the sun visor of FIG. 1 having a short length, non-telescoping support arm;

FIG. 10 is a perspective view of another aspect of the sun visor according to the present invention shown in an open core position and depicting the mounting of a mirror to one core half;

FIG. 11 is a perspective view of a completed sun visor showing one aspect of a fully optioned mirror assembly with a cover deployed in a closed position;

FIG. 12 is a perspective view, similar to FIG. 11, but with the cover deployed in an open position;

FIG. 13 is a cross-sectional view through the sun visor of FIG. 11 depicting the mounting of the mirror assembly to the core and cover;

FIG. 14 is a perspective view of another aspect of a sun visor according to the present invention having a mirror assembly mounted therein; and

FIG. 15 is a cross-sectional view of an alternate aspect of the sun visor of the present invention.

DETAILED DESCRIPTION

Referring now to the drawings, and to FIGS. 1–14 in particular, there is depicted a sun visor denoted generally by reference number 10 which includes a number of features, all described hereafter, which may be used in various combinations as well as individually, separate from the other features.

In general, the sun visor 10 includes a core 12, a cover 14 typically made of fabric, including synthetics and natural fabrics, a support arm formed of either a long length support arm 16 allowing telescoping movement of the sun visor 10 as described hereafter and as shown in FIGS. 7 and 8 or a short length support arm 18 shown in FIG. 9 which does not provide telescoping extension of the sun visor 10. The sun visor 10 may also include a mirror assembly shown in various feature combinations in FIGS. 11–14.

Referring now to FIGS. 2–4, the core 12 is in the form of a clam shell having a first clam shell portion or half 20 and a second portion or half 22. The core 12 is formed of a suitable, light weight, easily formed material, such as plastic. A plastic useable to form the core 12 maybe polypropylene, by example only.

The first and second core halves 20 and 22 are integrally and pivotally joined together along a living hinge portion or edge 24 extending between one longitudinal edge of each of the core halves 20 and 22.

The core halves 20 and 22 have a substantially mirror image configuration formed of opposed longitudinal edges joined together to form the living hinge 24, outer longitudinal edges 26 and 28, adjacent side edges 30 and 32, and adjacent side edges 34 and 36. The side edges 26 and 28 may optionally be formed as part of a pivotal flap section pivotable about a second living hinge or weakened portion 38 formed adjacent from each side edge 26 and 28.

As shown in FIGS. 1 and 2, an intermediate portion between the side edges 30 and 32 and an intermediate portion 40 between the side edges 30 and 32 of the first and second core halves 20 and 22, respectively, is recessed to form a space for insertion of one support arm 16 or 18 into the core 12. An end portion of the living hinge 24 between the core halves 20 and 22 is formed with an aperture 42 which, when the core 12 is in the closed, fully assembled position shown in FIG. 1, defines an open ended recess adapted for receiving a D-ring 44 for securing one end of the sun visor 10 to a latch member mounted in a vehicle head liner, not shown. The D-ring 44 is mounted in the core 12 by suitable clips, not shown.

The core 12 of the present invention is provided with a unique cover mounting means which insures a quick and secure mounting of the cover 14 on the outer surface of the core 12.

The cover mounting means includes an elongated, elevated cover attachment surfaces 50 and 52 respectively formed in the core halves 20 and 22. Each surface 50 and 52 is formed as one elongated projection extending between the side edges 30 and 34 and the side edges 32 and 36 or in a discontinuous fashion formed of multiple segments or projections. Each surface 50 and 52 terminates in a suitably formed outer mounting surface 54 and 56, respectively. Each surface 54 and 56 may be planar or have any other shape, such a smoothly curved concave or convex shape.

In the aspect of the surfaces 50 and 52 shown in FIGS. 2 and 3, each surface 50 and 52 has a generally C-shape, formed as a continuous member projecting outward from the main extent or plane of the core halves 20 and 22.

In attaching the cover 14 to the core 12, the core 12 and the cover 14 are juxtaposed as shown in FIG. 2 with cover 14 overlaying an outer surface of the core 12. In this arrangement, the outer peripheral edge of the cover 14 shown by reference number 58 projects outward beyond the periphery of the side edges 30, 32, 34 and 36 of the core 12. The outer peripheral edge 58 of the cover 14 is then folded over a peripheral lip 60 and 62 on each core half 20 and 22 and inward to a position in which the peripheral edge 58 of the cover 14 is in contact with and overlays each of the surfaces 54 and 56 on the surfaces 50 and 52. Sonic waves are then applied to the surfaces 50 and 52 to cause molecular vibration and melting of the surfaces 50 and 52 into the interstices of the cover thereby joining the cover 14 to the core halves 20 and 22, after cooling, in a secure connection or joint which extends substantially continuously about the entire periphery of the core 12.

As shown in FIGS. 2–4, alignment and stability enhancing members 70, 72, 74 and 76 are formed in complimentary positions in the core halves 20 and 22 so as to be disposed in close proximity with an opposed member, with contact also being possible, as shown in FIGS. 3 and 4, when the core halves 20 and 22 are folded into the closed, fully assembled position. The alignment members 70, 72, 74 and 76 may take any shape, with the generally angular, L-shape shown in FIG. 2 by way of example only.

Lock means are provided for securing locking the core halves 20 and 22 in a fully assembled, closed position shown in FIGS. 3 and 4. The lock means comprises a plurality of posts denoted generally by reference number 80 which are formed of a stem 82 and a head 84 having a radially outward extending periphery formed of at least two side arms 86 and 88. Rather than just two side arms 86 and 88, the entire periphery of the head 84 may be enlarged to a greater diameter or cross-section dimension than the diameter or cross-section of the stem 82 so as to provide an enlarged head which overhangs the outer periphery of the stem 82 as shown in FIG. 3. The posts 80 are deployed at a number of locations on one of the core halves 20 and 22, with the post 80 being shown by way of example only as being mounted on the core half 22.

A plurality of lock receivers 90 are formed in the other core half 20. The lock receivers 90 include an outer wall formed of at least two wall portions 92 and 94, with additional wall portions, including a third wall portion and even a fourth wall portion to form walls 92, 94, 95 and 97 as a completely closed, continuous wall may also be employed. Lock members are resiliently mounted on and

5

extend from an end of at least two of the side walls **92** and **94**. The lock members all denoted generally by reference number **96** include a leg **98** which terminates in an outer end **100**. The legs **98** of the lock members **96** are disposed at an acute angle from the adjacent side wall **92** or **94** such that the outer end **100** is pivotal about the connection between the legs **98** and the adjacent side walls **92** and **94** of each receiver **90**. This pivotal movement allows the head **84** of a complementarity positioned lock post **80** on the mating core half **22** to slide through the space normally existing between two adjacent lock legs **98** thereby urging the outer ends **100** outward until the head **84** snaps past the outer ends **100** of the legs **98**. The legs **98** then snap back toward the nominal position and seat against a shoulder formed between the inner surface of the side arms **86** and **88** of the head **84** and the adjacent outer surface of the stem **82** thereby securely locking the lock post **80** in the receiver **90**. The same locking process occurs across the entire core **12** at every location of a matingly positioned receiver **90** and lock post **80**.

Referring again to FIGS. **1** and **2**, and in greater detail in FIGS. **5** and **6**, the support arm **16** is mounted within the core **12** prior to locking closure of the core halves **20** and **22** as described above. The support arm may take one of two configurations, including the telescoping, long length support arm **16** shown in FIGS. **7** and **8** and the shorter length support arm **18** shown in FIG. **9** for non-telescoping sun visors.

Regardless of the length of the support arm **16** or **18**, the end portion of each support arm **16** or **18** includes at least one and preferably a pair of flats **110** adjacent an outer end **112**, with only the support arm **16** being depicted in FIG. **5** by way of example only. The remainder of the support arm **16** may have a circular cross-section, by example only. A stop flange **114** is spaced from the outer end **112** of the support arm **18** to retain the support arm **18** in a slide carrier **120**. The carrier **120** defines an integral, one piece body, typically of a molded plastic, having a pair of side arms **122** and **124**, each with an aperture **126** and **128**, respectively, the apertures **126** and **128** being coaxially aligned for receiving the end portion of the support arm **18** with the flats **110** disposed between the side arms **122** and **124**.

A first pair of apertures **130** are formed in a central leg **132** of the slider **120**. A second pair of apertures **134** are also formed in the central leg **132** of the slider **120**. The pairs of apertures **130** and **134** receive bent edges **136** and **138** of a spring clip **140** to attach the spring clip **140** to the slider **120**. The spring clip **140** has an enlarged end portion denoted by reference number **142** which receives the end portion of the support arm **16**. A pair of bent portions **144** and **146** on the spring clip **140** resiliently engage the flats **110** on the end of the support arm **18** to exert a biasing force tending to retain the entire sun visor **10** in a fixed position, typically biased in a direction toward the vehicle headliner in a normal, stored sun visor position to minimize buzz, squeaks or rattles. This provides the necessary noise control features for the sun visor **10** of the present invention.

The sun visor **10** has a unique telescoping mount using the slide carrier **120** which may be used by itself or in combination with the heat stake cover attachment described above as well as with or without any of the additional unit features of the sun visor described hereafter.

The slide carrier **120** includes first and second, oppositely directed, open ended channels **150** and **152** which are integrally formed in the carrier **120**. The open end of the channel **150** extends oppositely from the open end of the channel **152**. The channels **150** and **152** are positioned to

6

engage slide rails **154** and **156**, shown in FIGS. **2**, **6**, **7** and **8** which are integrally formed as part of the core halves **20** and **22**, respectively. The slide rails **154** and **156** extend along the length of each core half **20** and **22**, generally in parallel with the hinge **24**.

When the core halves **20** and **22** are locked in the fully assembled, closed position shown in FIG. **6**, the slide rail **154** engages the channel **150** and the opposed slide rail **156** engages the opposite channel **152** in the slider **120**. This dual, opposed slide rail and channel configuration securely retains the slider **120** in a constant orientation during all telescoping movement of the sun visor **10** relative to the support arm **16** as described hereafter. The addition of the second channel **150** and the slide rail **154** provides added stability to insure a smooth, even bi-directional telescoping movement of the sun visor **10** along the support arm **16** while at the same time securely retaining the sun visor **10** to the support arm **16**.

FIG. **7** depicts the normal, non-telescope position of the sun visor **10** relative to the support arm **16**. In this position, the carrier **120** is disposed adjacent to the D-ring end of the sun visor **10**. When the vehicle occupant desires to laterally extend the position of the sun visor **10** relative to the support arm **16**, the occupant grasps the sun visor **10** and slides the sun visor **10** along the support arm **16** to any position up to a maximum extend position shown in FIG. **8**. In the maximum extended position, the carrier **120** is disposed adjacent to a support arm pivot support or clip **160**. The clip **160**, shown in FIGS. **7**, **8** and **9**, includes a wall integrally formed on one of the core halves, such as the second core half **22** having an aperture **162** for receiving the support arm **16** therethrough. The portion **164** of the wall **160** carrying the aperture **162** is spaced from a collar **166**, also formed on the core half **22**, which defines a generally circular cross-section bore through which the support arm **16** extends.

The sun visor **10** may also be provided with the short length support arm **18** for non-telescoping use without any modifications to the core **12**. By example only, the non-telescoping aspect of the present sun visor **10** also employs the carrier **120**, the support wall **160** and the sleeve **166**. However, the carrier **120** is non-laterally moveably disposed within the wall **160** as shown in FIG. **9**.

Referring now to FIGS. **10–14**, there is depicted several aspects of a mirror assembly which may be optionally employed with the sun visor **10** of the present invention. It will be understood that the various aspects of the mirror assembly described hereafter are useable independently or in combination with any of the telescoping, fabric cover mount or core lock means described above.

In one aspect of a mirror assembly shown in FIG. **10**, which preferably applies to all the mirror assemblies described hereafter, a shallow recess **170** is formed in the core half **22** projecting slightly out of the plane of the main extent of the core half **22**. The recess **170** is formed by a wall **172**.

At least one and preferably a plurality of spaced apertures **174** are formed in the wall **172**. Each aperture **174** is alignable with a corresponding lock receiver **90** on the mating core half **20**. Each aperture **174** is positioned to receive a lock post **80**, identical to the lock post **80** described above for locking the core halves **20** and **22** in the fully closed, assembled position, but now provided on a back plate **176** of a frame or mirror support. The lock posts **80** project from the back wall or plate **176** so as to extend through the apertures **174** and the wall **172** and into locking engagement with the mating receiver **90** when the core

halves **20** and **22** are pivoted to the fully closed position. This enables the mirror assembly to be fixedly attached to the core **10** at the same time the core halves **20** and **22** are locked in the closed, fully assembled position.

FIGS. **11** and **12** depict an opposite surface of the core half **22** which has the recess **170** formed therein for receiving a mirror assembly **182**. In this aspect of the mirror assembly **182**, the mirror assembly **182** includes a moveable or pivotal cover **184** which is pivotally mounted to a frame **186** formed of a fixed frame member **188** attached to the back plate **176** shown in FIG. **10** and a mirror surround frame **190**, only a portion of which is shown in FIG. **11**. The cover **184** has a generally planar extent, with depending side walls and a raised edge **192** to permit easy pivotal movement of the cover **184** between open and closed positions shown in FIGS. **12** and **11**, respectively. A hinge **189** is provided between a fixed frame element **188** and the cover **184**.

The mirror assembly **182**, as shown in FIG. **12**, also is provided with an illumination means in the form of one or more lamp means **196** and **198** mounted in the mirror surround frame **190** on at least one and preferably opposed sides of a reflective mirror **200**. The mirror **200** is typically adhesively joined to the back plate **176**. Conductors for conducting power to the light means **196** and **198** located below the bezzles or lenses **202** are routed between the closed core halves **20** and **22** and into an aperture formed in the support arm **16** or **18** whereby the wires exit the sun visor **10** and pass through the vehicle interior, typically through the vehicle A pillar to the accessory power vehicle circuit.

According to a unique aspect of the present invention, the mirror assembly **182** is mounted on the sun visor **10** after the core halves **20** and **22** of the sun visor **10** have been pivoted to the closed, latched position. As shown in FIG. **13**, the lock post **80** may be forced through the fabric cover **14** into the underlying receiver **90** to fixedly mount the mirror assembly **182** to the sun visor **10**. The layer of the cover fabric **14** disposed between the back wall **176** of the mirror assembly **182** and the core half **20** minimizes the generation of buzzes, squeaks and rattles.

It will be understood that the mirror assembly **182** may be provided without the lamp means **196** and **198** and with or without the pivotal cover **184**. Another mirror assembly **210** is depicted in FIG. **14**. In this aspect, the mirror apparatus is formed of a multi-sided frame **212** which surrounds a mirror **214** secured, typically by adhesive, to a back plate, not shown. The back plate can be identical to the back plate **176** so as to carry the lock posts **80** for secure attachment of the mirror assembly **210** to the core half **22** as described above.

As shown in FIG. **15**, the core **10** having the recess **172** formed in one of the core halves for receiving one of the mirror assemblies described above, may also be utilized without any mirror assemble. In this application, a filler member **220** has a peripheral shape complementary to the shape of the recess **170** in the core half **22** and a thickness substantially the same as the depth of the recess **170**.

In use, the filler member **220** is mounted within the recess **170** and covered by the cover **14** which holds the filler member **220** in the recess **170**. Alternately, the filler member **220** may be fixed in the recess **170** by means of adhesive, etc.

The use of the filler member **220** provides a flush surface with the surrounding surface of the core half **22** when a mirror assembly is not used in the sun visor **10**. At the same time, the filler member enables a single core **12** design to be employed with and without a mirror assembly without requiring any modification or additional manufacturing cost.

In summary, there has been disclosed a unique vehicle sun visor having improved fabric cover attachment, easy and reliable telescoping visor movement, the option to switch between a telescoping support arm and a fixed short support arm without modification to the sun visor core so as to contribute to a reduced manufacturing cost, multiple mirror assembly mounts, unique and reliable core lock members, and a mirror attachment means which controls or minimizes the generation of noise between the contacting parts of the mirror and the sun visor core.

What is claimed is:

1. A method of manufacturing a sun visor comprising the steps of:

forming a core with first and second core halves extending oppositely from a common hinge;

forming a receiving surface on each of the first and second core halves defining an elongated attachment area spaced from a periphery of the first and second core halves;

overlaying the core and a covers, with edge portions of the cover extending beyond the periphery of the core halves;

folding peripheral edge portions of the cover over peripheral edges of the first and second core halves into contact with the receiving surfaces on the first and second core halves; and

joining the edges of the cover to the receiving surface.

2. The method of claim 1 wherein the step of forming the receiving surfaces comprises:

forming the receiving surface on at least one of the first and second core halves as a continuous surface between opposed ends of the one of the first and second core halves.

3. The method of claim 2 further comprising the step of: forming an outer end of each receiving surface as a planar surface.

4. The method of claim 1 wherein the step of forming the core further comprises:

forming each of the first and second core halves with opposed sides extending from the common hinge edge, and one longitudinal edge spaced from the common edge; and

forming the receiving surface on each of the first and second core halves along the opposed side edges and the longitudinal edge.

5. The method of claim 1 further comprising the step of: forming the receiving surfaces in the first and second core halves in a spatial relationship so that the receiving surfaces on the first and second core halves overlay each other in substantial alignment when the first and second core halves are folded together about the common hinge edge.

6. A sun visor constructed in accordance with the method of claim 1.

7. A sun visor comprising:

a core with first and second core halves extending oppositely from a common hinge;

a receiving surface defining an elongated attachment area on each of the first and second core halves spaced from a periphery of the first and second core halves;

the core overlaid with a cover, with edge portions of the cover extending beyond the periphery of the core halves;

peripheral edge portions of the cover folded over peripheral edges of the first and second core halves into

9

contact with the receiving surfaces on the first and second core halves; and
the peripheral edges of the cover folded over and joined to the receiving surfaces.
8. The sun visor of claim **7** wherein:
the receiving surface on at least one of the first and second core halves extends continuously between opposed ends.
9. The sun visor of claim **7** further comprising:
a hinge formed at a common edge between the first and second core halves.
10. The sun visor of claim **9** further comprising:
each of the first and second core halves defined by opposed side edges extending from the common edge and one longitudinal edge extending between the opposed side edges and spaced from the common edge; and
the receiving surfaces in each of the first and second core halves extending along the opposed side edges and the longitudinal edge.

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11. The sun visor of claim **7** wherein:
the receiving surface in at least one of the first and second core halves defines a planar surface raised from a plane extending through a major extent of at least one of the first and second core halves.
12. The sun visor of claim **7** further comprising:
the receiving surfaces in the first and second core halves disposed in an overlaid, spatial relationship when the first and second core halves are folded together about the common edge.
13. The sun visor of claim **7** wherein:
the peripheral, folded over edges of the cover are welded to the receiving surfaces on the first and second core halves.
14. The method of claim **1** wherein the joining step further comprises the step of:
welding the peripheral, folded over edges of the cover to the receiving surfaces.

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